

Date: Monday, 03/11/2008 1:07:12 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE KIT FOR D206-642-512
Job Number : 43154	
Estimate Number : 12894	
P.O. Number :	Part Number : K642 512
This Issue : 03/11/2008 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : N/A
Previous Run : 40259	Material :
Written By :	Due Date : 12/11/2008 Qty: 2 Um: Each
Checked & Approved By : <u>JUD 08.11.03</u>	
Comment : Est Rev:A 05.06.07 new issue EC Est. Rev.B 05.02.08, Per ECN1080P	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: Create White labels per PPP K642-512 CHG003

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Pick Packing Kit

3.0	D206648013	GHW Modification
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: CHC7007

Qty Part Number	Description	Batch
1 D206-648-013	GHW Kit	B413410

9/4/29

50

4.0	D2652	Bushing
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
16 D2652	Bushing	B45312

9/4/29

50

5.0	D2712	Set Screw
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Comment: Qty.: 10.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
10 D2712	Set Screw	B42810

9/4/29

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Seq. #: Machine Or Operation: Description :

6.0 D29322 Saddle RH Out, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2932-2 Saddle BH0220

9/4/29

SP

7.0 D29332 Saddle RH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2933-2 Saddle B41129

45321 9/4/29

8.0 D2934 Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D2934 Saddle Spacer B44290

9/4/29

SP

9.0 D2935 Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D2935 Saddle Spacer B44553

9/4/29

SP

10.0 D29382 Saddle RH Out, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2938-2 Saddle B41131

B44555

9/4/29

SP

11.0 D29392 Saddle RH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2939-2 Saddle B43412

9/4/29

SP

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Seq. #: Machine Or Operation: Description :

12.0 D33963 Spacer



9/14/29



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3396-3 Spacer B36334

sf

13.0 D3407043 Tow Ring



9/14/29



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3407-043 Tow Ring B43308

sf

14.0 D34561 Washer



9/14/29



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3456-1 Washer B43002

sf

15.0 D34571 Washer



9/14/29



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3457-1 Washer B44793

sf

16.0 AN3C35A BOLT



9/14/29



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number Description Batch
3 AN3C35A Bolt M108323

sf

17.0 AN3C36A BOLT



9/14/29



Comment: Qty.: 9.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number Description Batch
9 AN3C36A Bolt M129771

sf

W/O:		WORK ORDER CHANGES					
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Seq. #: Machine Or Operation: Description :

18.0 AN3C41A BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN3C41A

Bolt

M108409

9/4/29

SP

19.0 AN4C6A Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 AN4C6A

Bolt

M109147

9/4/29

SP

20.0 AN5C11A



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN5C11A

Bolt

M109898

9/4/29

SP

21.0 AN5C12A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C12A

Bolt

M107328

9/4/29

SP

22.0 AN5C13A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C13A

Bolt

M107615

9/4/29

SP

23.0 AN5C15A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C15A

Bolt

M109148

9/4/29

SP

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN5C32A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C32A

Bolt

M101463

9/4/29

SP

25.0

AN5C34A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C34A

Bolt

M10728

9/4/29

SP

26.0

AN5C35A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C35A

Bolt

M107551

9/4/29

SP

27.0

AN960C10L

washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C10L

Washer

M111424

9/4/29

SP

28.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C416L

Washer

M111127

9/4/29

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. #: Machine Or Operation: Description :

29.0 AN960C516L WASHER



9/4/08



Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch
8 AN960C516L Washer M109545

SP

30.0 MS210433 Nut



9/4/08



Comment: Qty.: 20.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:

Qty Part Number Description Batch
20 MS21043-3 Nut M111274

39
①
M111383

SP

31.0 MS210434 Nut



9/4/08



Comment: Qty.: 13.0000 Each(s)/Unit Total: 26.0000 Each(s)

Pick:

Qty Part Number Description Batch
13 MS21043-4 Nut M111424

SP

32.0 MS210435 Nut



9/4/08



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 MS21043-5 Nut M109053

SP

33.0 D36721 Phenolic Washer



B342329

9/4/08



SP

Comment: Qty.: 24.0000 Each(s)/Unit Total: 48.0000 Each(s)
PHENOLIC WASHER

34.0 D36723 Phenolic Washer



B344176

9/4/08



2x

Comment: Qty.: 24.0000 Each(s)/Unit Total: 48.0000 Each(s)
PHENOLIC WASHER

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D36725

Phenolic Washer



B35521

9/14/08



SP

Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

PHENOLIC WASHER

36.0

D36727

Phenolic Washer



B35522

9/14/08



(24)

Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

PHENOLIC WASHER

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

509/04/09 (22)

38.0

PACKAGING 1

PACKAGING RESOURCE #1



(24)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP K642-512 CHG003

Location

PK New Draft 9/14/09

SP

39.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/30 H

Comment: FINAL INSPECTION/W/O RELEASE

MF 09-04-29

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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